Work Orde Wednesday, Octo			.5	*748	64*		v.			Page 1
Revision ID: Item Name:	D3183-9  Cap 10/12/2011 10/13/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		*N900 Cust Item Customer:	ID:	ogons	Setup Star	i Ni	S1* S2*
Approvals:	Process Pla	n: MF	Date: 11-16-1	Tooling:	D	Pate:	F	Run Sta	rt *N	R1*
	QC:	·	Date:	SPC (Y/N):	D	ate:		Sto	<sup>p</sup> *N	R2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID		lan Accept ode Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	·	ision Nbr								
D3183	Rev	C1		1						
*100 *100* Hardinge Hardinge CNC Lathe	e Small	Hardinge CNC LATHE S  Memo  Turn D3183-	MALL  Grap as per Folio FA38	0.00 0.00  BDeburr 11)10/12			40	Þ		
110		QC2- Inspect parts off ma	chine FAI/FAIB	0.00					/	
*110* QC Quality Control		Memo		0.00	·		40	P		
		<u>.</u>		WOOD						
120		QC8- Inspect parts - secon	id check	0.00	•					
*120* QC Quality Control		Memo	<del>-</del> <del>-</del> <del>-</del> <del>-</del> <del>-</del> <del>-</del> <del>-</del> - <del>-</del> <del>-</del> - <del>-</del> <del>-</del> - <del>-</del> <del>-</del> - <del>-</del>	0.00	SLIF-10-13		· ·			
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W/O:			WC	ORK ORDER CHANG	ES		- 6-	*
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			**	•		,		
								<u> </u>
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:	Date:	<u> </u>
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)		
DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							·	
ļ			[ ]		1		1	1

Work Order ID 74864 Wednesday, October 12, 2011 3:53:29 PM					*748	364*							Page 2
Revision ID: Item Name: Start Date:	D3183-9 Cap 10/12/2011	Start Qty: 40.00		*40*	Accept	*N9000		100	)*	Setup	Start Stop	*N.S	\$1* \$2*
Required Date: Reference:	10/13/2011	Req'd Qty: 40.00		*40*		Customer:							
Approvals:	Process Pla	ın:	Date:_		Tooling:	Da	te:	_	]	Run	Start	*NF	<b>?1</b> *
	QC:		Date:_	-	<b>SPC (Y/N):</b>	Da	te:				Stop	*NF	22*
Sequence ID/ Work Center ID 130	)	Operation Description Identify as per dwg & Sto	ck Locatio	n: <b>SFJ</b> 3V	Set Up/ Run Hours Q : 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty			Insp. Stamp
*130* Packaging Packaging		Мето	٠		0.00			(40	<u>)</u>	<u>8</u>	<u>P</u> [	1-19	<u>5-13</u>

140

\*14**0**\* Quality Control-

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

M 10/13/2/3

Dart Aerospac	e Ltd
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W/O:			WO	RK ORDER CHANG	ES			5	, ,
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								•	
									<i>*</i> '.
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes 1	No DQA	<b>\</b> :	_ Date: _	
		esolution:							
NCR:		1	WORK ORDI	ER NON-CONFORMA	ANCE (NCR)	)			
DATE	DATE STED Description of NC			on B	Verification			Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		Section C		QC Inspector
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						:			

Wednesday, October 12, 2011 3:53:29 PM

Work Order ID:

74864

Parent Item:

D3183-9

Parent Item Name:

Cap

Start Date: 10/12/2011

**Required Date:** 10/13/2011

**Start Qty: 40.00** 

Required Qty: 40.00

Page 1

Comments:

IPP A 06.05.03 New issue KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000 Delrin Round Bar 1"		Purchased	No		·	100	f	31.1180	0.0333	1.402105	3///0	11-	7
				Location		Loc Oty	<u>Lo</u>	c Code	· · · · · · · · · · · · · · · · · · ·				
				MAT055		31.118 0.407					_		
				11825		17.002 13.709				401		,	

1 bearing 13183-5

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W/O:			W	ORK ORDER CHANGI	ES		· r	э
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng /	Approval QC Inspector
							Prod Mgr	QO MSpecior
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Cld	sed:	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCR			
	0750	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	74864 .
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		X First Arti	cle	Prot	otype
Drawing	Tolerance	Actual	Accent	Daiset	Method
Dimension	loierance	Dimension	Accept	Reject	Inspect

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
Ø0.830	+/-0.005	839	-(		9	
Ø0.720	+/-0.002	121	\rightarrow \cdot			
Ø0.747	+/-0.001	.248	/,			
R0.010	+/-0.010	2.010			1	
R0.031	+/-0.010	2.030	<i></i> ,			೮
0.199	+/-0.001	1192				
0.276	+/-0.010	,276	/			
0.039	+/-0.010	-040				
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				"		

Measured by:	12	Audited by:	Prototype Approval:	N/A
Date:	W/CV12	Date: //-/0-/3	Date:	N/A

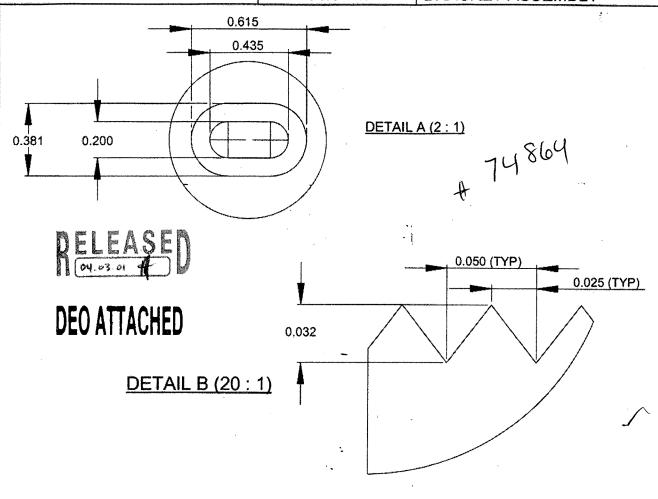
Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue (P/O D3183-045)	KJ/RF	1
В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	ad
			77	——————————————————————————————————————

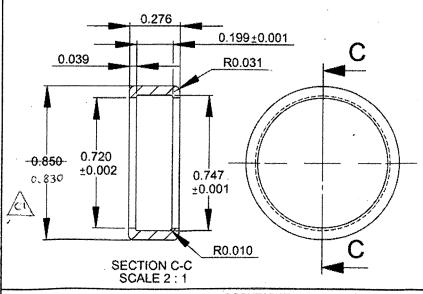
W/O:			WO	RK ORDER CHANGE	ES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:		PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
		esolution:	_ Disposition	1:	QA: N/C Closed:			Date:	
NCR:				R NON-CONFORMA					
		Description of NC	Corrective Action Section			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Secti	ion C	Chief Eng	QC Inspector
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	1								
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	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
)	CHECKED	APPROVED	D3183	REV. C				
	DATE 04.	02.17	BRACKET ASSEMBLY	SCALE 1:1				





#### D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
- (REF DART SPEC. M-DELRIN-R1.00)
  2) TOLERANCES ARE PER DART QSI 018
- UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

#### **D3183-045 BEARING ASSEMBLY**

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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W/O:		.,	WC	RK ORDER CHANGE	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No: PAR #: Resolution:		PAR #:	Fault Cate	gory:	NCF	R: Yes N	lo <b>DQ</b>	<b>\</b> :	_ Date: _	
		esolution:	Disposition: Q/			A: N/C Closed:			Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section		on B	O: 0	Verification		Approval	Approval
DAIE			Initial Chief Eng	Action Description Chief Eng	İ	Sign & Date	Section	Section C Chief 6	Chief Eng	
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